



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBE350A94-3301-00

Job Sheet 180171



Part No: RBE350A94-3301-00

Job Qty: 20 ea

Part Name: T/R Accelerator Support



Part Weight: 0 lbs

Status: At Planning

Priority: Medium

Job Created: 6/29/18

Job Tracking No:

Due Date: 7/30/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG RBE350A94-3301-00 Rev 4 IPP Rev A 17.12.21 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea		7/30/18	0.00	0.00	Start Up Machining		J.C. 2
110	Mori Seiki	20 pcs		7/30/18	0.00	40.00	MORI NV5000-1		J.C. 2
120	QC	20 pcs		7/30/18	0.00	0.00	QC2-2		J.C. 2 18-09-25
130	QC	20 pcs		7/30/18	0.00	0.00	QC8		18-09-28
150	Outsource	20 pcs		7/30/18			GRO002-VC	10	OCT 0 1 2018
160	Packaging	20 pcs		7/30/18	0.00	0.00	Packaging2		OCT 1 0 2018
170	QC	20 pcs		7/30/18	0.00	0.00	QC6		38
180	Packaging	20 pcs		7/30/18	0.00	0.00	Packaging3-1		ML 9-89
190	QC21-FG	20 Ea		7/30/18	0.00	0.00	QC21		18-10-12

Part Op 90 - See engineering for material sign off. Was 6063 T extrusion Now is 7075 T extrusion.
 Descriptions: 110 - 1-Machine as per folio FB979 FOLIO REV: _____ DWG REV: _____ Engrave part number and batch number And T/N number 2-Deburr
 130 - Engrave T/N And / or S/N number as required Using Marktronic engraver as per DWG.
 150 - Issue P/O to ATG: 18091136 - ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1 WATER SEAL -Certificate of Conformity is required

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
649.5013E	Deflector	13 ft (.65 ea)	90-Start up Operation	F92 313

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	649.5013E	13	72	0

Part Specifications

Specifications could not be found.

Dart Aerospace Ltd.
1270 Aberdeen Street
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CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com



Container No: S113375



Part: RBE350A94-3301-00

Job No: 180171

Serial No/Batch: S113375

Revision: 4

Inspector:

Exp Date:

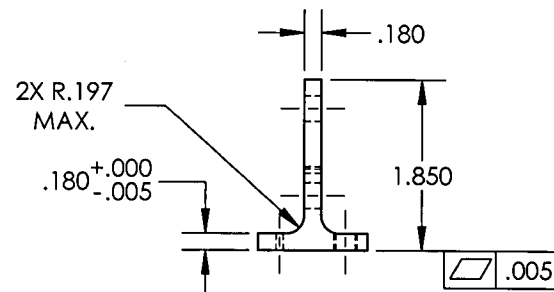
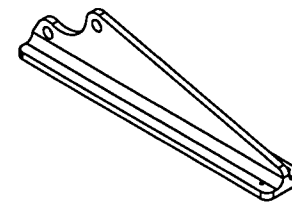
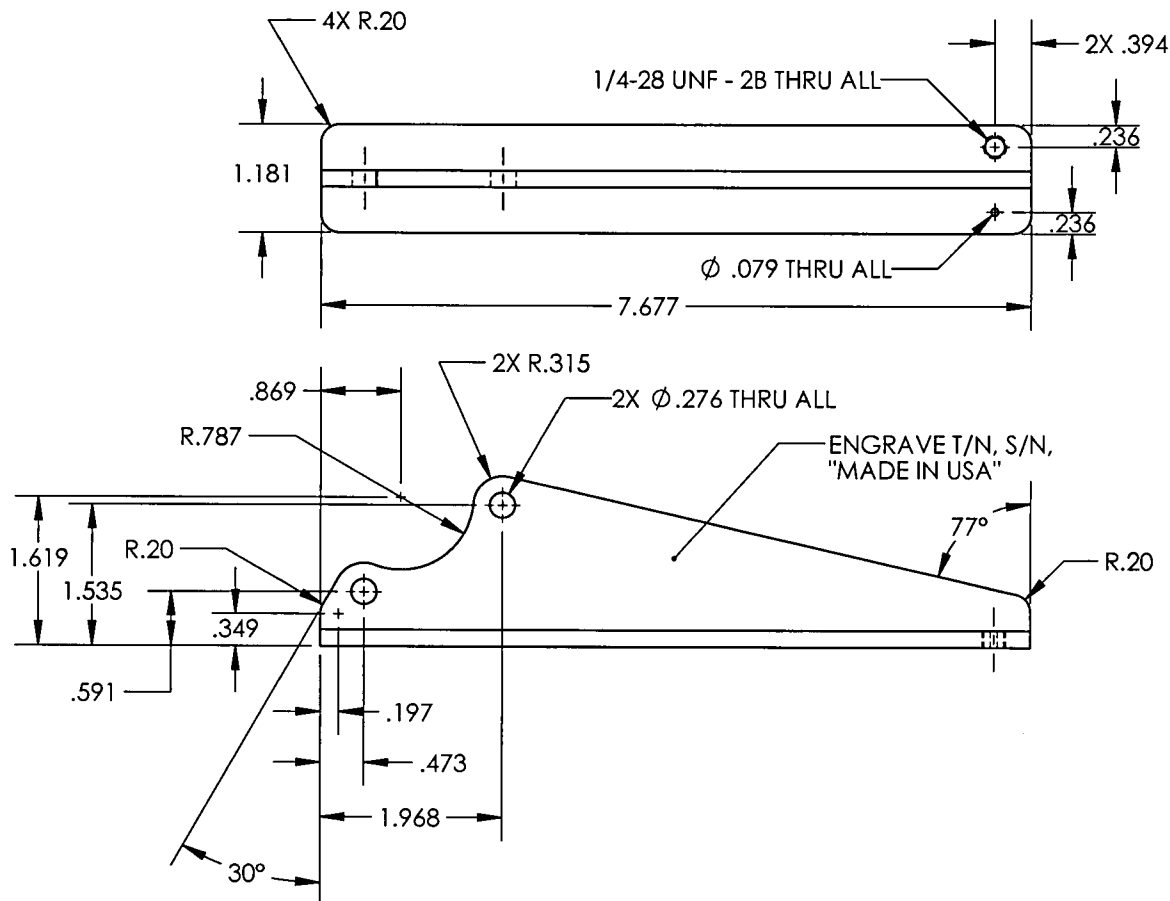
Instructions:

Date: 09/25/18

Plex 6/29/18 1:54 PM dart.logan.david

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		DESIGNED PER HELI PRODUCTS TOOLS.	9/9/2009	WP	DW
1A		ADDED MISSING DIMENSIONS, ADDED ENGRAVE NOTE PER R.W.	9/15/2011	RJC	RW
2		CORRECTED DIMENSION FROM .676 TO .667, ADDED OPTIONAL TO R.197 DIMENSION, ADDED FLATNESS CONTROL TO BOTTOM OF TOOL, CH'D MATERIAL FROM 2024 T-BAR PER R.W.	5/9/2012	RJC	RW
2A		CH'D T/N WAS RBEA94-3301-00 IS RBE350A94-3301-00.	11/6/2013	RJC	RW
3		CH'D DIM WAS .188 IS .180 +.000/-0.005.	4/11/2014	DPD	GE
4	16-0256	CH'D DIM WAS .180 +.000/-0.005 IS .180 WAS 4X R.197 IS 4X R.20, WAS R.197 IS R.20 IN TWO PLACES, WAS 1/4-28 UNF IS 1/4-28 UNF -2B THRU ALL, WAS Ø.079 IS Ø.079 THRU ALL, WAS 2X Ø.276 IS 2X Ø.276 THRU ALL, WAS 2X R.197 OPTIONAL IS 2X .197 MAX, DELETED DIMS Ø.250 TOOLING HOLE, 5.750, .667, CH'D MATERIAL WAS 6063 T CHANNEL IS 6063.	12/6/2016	RJC	JAG



DART AEROSPACE	
TITLE T/R ACCELERATOR SUPPORT	
DWG NO. RBE350A94-3301-00	REV 4
MAT'L 6063	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH CLEAR ANODIZE	.XX ± .01 ANGLES ± 5°
SPEC MIL-A-8625F, TYPE II, CLASS I	.X ± .1 SURFACES = 125/
DRAWN BY: PERRITT	1. BREAK ALL SHARP EDGES .015 x 45° OR .016R
CHECKED: MACKOVJAK	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	AS350/AS355
SCALE 1:2	DATE 9/9/2009
SHEET 1 OF 1	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
				1		6063		

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____

Date: _____

Work Order update only ☐

Work Order: _____ Part No. <u>RBE350A94-3301-00</u> NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step # : _____		QTY Effective : _____			MRB (QSI042) Approval March 23, 2018		
Description Work Order Deviation				Disposition					
RBE350A94-3301-00 can be manufactured from 7075-T6 as an alternative material.				- This deviation is acceptable. - The fit, form and function of the tool will be as originally intended.				Completed By 18-09-24	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause				FAULT CATEGORY					
Environment ☐	☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Design ☐	☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐			
Doc/Data ☐	☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐			
Equip/Tooling ☐	☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐			
Handling/Pre ☐	☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐			
Material ☒	☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐			
Internal Transport ☐	☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐			
Tribal Knowledge ☐	☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐			
LOA ☐	☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐			
Substation ☐	☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐			
Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER : _____						
Misidentified ☐	☐	Past Due ☐							



Dart Aerospace Ltd.
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PURCHASE ORDER **PO041186**

Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO041186

PO Date: 10/1/18

Due Date: 10/12/18

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Via: Ground

Pynt Terms: Net 30

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	182799	RBEM632V4000102-3	Clamp Base -Issue P/O to ATG: ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1 WATER SEAL -Certificate of Conformity is required	Firmed	-	10/12/18	6 pcs	0 pcs	6 pcs	\$4.77/pcs	\$28.62
2	181923	644.4119	Spacer, Fwd Stop 1-ISSUE P/O TO ATG: 2-Anodize Black -MPP-172 Section 2.1 -Hard Anodize IAW Mil-A-8625 Type 3 Class 2 3-Certification of Conformity is required	Firmed	-	10/12/18	50 pcs	0 pcs	50 pcs	\$4.17/pcs	\$208.50
3	181918	644.4113	Spacer, Stop 1-ISSUE P/O TO ATG: 2-Anodize Black -MPP-172 Section 2.1 -Hard Anodize IAW Mil-A-8625 Type 3 Class 2 3-Certification of Conformity is required	Firmed	-	10/12/18	30 pcs	0 pcs	30 pcs	\$3.87/pcs	\$116.10



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PURCHASE ORDER

PO041186

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	181925	644.4122	EC145 Fwd Crosstube Bushings 1-ISSUE P/O TO ATG: 2-Anodize Black -MPP-172 Section 2.1 -Hard Anodize IAW Mil-A-8625 Type 3 Class 2 3-Certification of Conformity is required	Firmed	-	10/12/18	30 pcs	0 pcs	30 pcs	\$5.82/pcs	\$174.60
5	182800	RBEM632V4000102-5	Clamp Top -Issue P/O to ATG: ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1 WATER SEAL -Certificate of Conformity is required	Firmed	-	10/12/18	6 pcs	0 pcs	6 pcs	\$4.77/pcs	\$28.62
6	181926	644.4123	EC145 Fwd Crosstube Bushing 1-ISSUE P/O TO ATG: 2-Anodize Black -MPP-172 Section 2.1 -Hard Anodize IAW Mil-A-8625 Type 3 Class 2 3-Certification of Conformity is required	Firmed	-	10/12/18	30 pcs	0 pcs	30 pcs	\$5.82/pcs	\$174.60
7	180171	RBE350A94-3301-00	Tail Rotor Accelerator Support -Issue P/O to ATG: ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1 WATER SEAL -Certificate of Conformity is required	Firmed	-	10/12/18	20 pcs	0 pcs	20 pcs	\$4.477/pcs	\$89.54
Grand Total:										\$820.58	

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PURCHASE ORDER PO041186

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

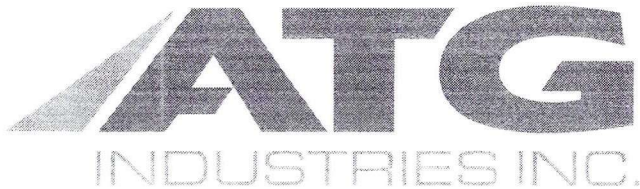
A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 10/2/18 1:54 PM dart.tsimiklis.chrisoula



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 916201

Date: 10-Oct-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chrisoula Tsimiklis
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
✓ 20 ea	Part: RBE350A94-3301-00 ✓ Tail Rotor Accelerator Support Clear Anodize per MIL-A-8625F, Type II, Class 1, Water Seal .0004-.0010" (.4 - 1 mils). Job: 23840	Rev: 4 PO: PO041186 ✓	Line:
✓ 6 ea	Part: RBEM632V4000102-3 ✓ Clamp Base Clear Anodize per MIL-A-8625F, Type II, Class 1, Water Seal .0004-.0010" (.4 - 1 mils). Job: 23834	Rev: 1 PO: PO041186 ✓	Line: 1
✓ 6 ea	Part: RBEM632V4000102-5 ✓ Clamp Top Clear Anodize per MIL-A-8625F, Type II, Class 1, Water Seal .0004-.0010" (.4 - 1 mils). Job: 23838	Rev: 1 PO: PO041186 ✓	Line: 5
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>10/10/2018</u> Certified Signature: <u>[Signature]</u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt. Made in Canada.			

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